Work Order ID 61788

Friday, September 03, 2010 10:13:11 AM



Page 1

Item ID: D3781-041 Accept Setup Start **Revision ID:** Stop Item Name: Lateral Cushion Assembly **Start Date:** 9/3/2010 Start Qty: 4.00 **Cust Item ID:** Req'd Qty: 4.00 Required Date: 9/13/2010 **Customer:** Reference: Run Start Date: 10-9-03 **Tooling:** Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Set Up/ Accept Reject Reject Insp. Work Center ID **Description Run Hours** Code **Qty Qty** Number Stamp Draw Nbr **Revision Nbr** D3781 Rev E 100 0.00 CZ 10/9/03 (4) Purchasing 0.00 Memo Purchasing Issue P/O: Ship with D3781-1 SUPPORTING PLATE Material: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT) AND COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111. BOND D3781-3 TO D3781-1 AND FABRIC USING 3M

> 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS THREAD:MIL-VT-295 TYPE2 CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS.

Possible Supplier: AEROTEX INTERIORS INC.

Material release note is required

110

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

10/1/22 (4)

Packaging

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					-						
Part No	•	PAR #:	Fault Cate	gory:	NCR : Ye	s No	DQA:	_ Date: _			
ř	R	esolution:	Dispositio	n:	QA: N/C	Closed:		Date: _			
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NO	CR)					
DATE	STEP	Description of NC			tion B	Ve	erification	Approval	Approval		
DAIL	SIEF	Section A	Initial Chief Eng			Sign & Section		Chief Eng	QC Inspector		
					ŀ						

Work Order ID 61788

Friday, September 03, 2010 10:13:11 AM



Page 2

Item ID:

D3781-041

Accept

Setup Start

Stop

Revision ID:

Item Name:

Lateral Cushion Assembly

Start Date:

9/3/2010

Start Qty: 4.00

Req'd Qty: 4.00



Cust Item ID: Customer:

Reference:

Required Date: 9/13/2010

Approvals:

Process Plan:

Date:

Date: _____

Tooling: SPC (Y/N):

Date:

Date:

Run

Start

Stop

Sequence ID/ **Work Center ID**

120

Quality Control

Operation Description

QC6- Inspect dimensions to drawing

Memo

Set Up/ **Run Hours**

0.00

0.00

510/01/23

Tool ID

Tool # Plan Code Qty

Accept

Reject Reject Qty

Number

Insp. Stamp

124

Small Fab

Small Fab

Memo

0.00

0.00

1- Locate and remove fabric from hole as per dwg

126

QC5- Inspect part completeness to step on W/O

0.00 5 10/09/23

Quality Control

Memo

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
								Prod Wgi				
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Part No	·	PAR #:	Fault Ca	tegory:	NCR: Yes							
	R			Disposition: QA: N/C Closed:								
NCR:		. V	VORK OR	DER NON-CONFORMA	NCE (NCF	R)						
DATE	STEP	Description of NC	of NC Corrective Action		n B		cation	Approval	Approval			
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Work Order ID 61788

Friday, September 03, 2010 10:13:11 AM



Page 3

Item ID:

D3781-041

Accept



Setup Start



Revision ID:

Item Name:

Lateral Cushion Assembly

Start Date:

Required Date: 9/13/2010

9/3/2010

Start Qty: 4.00

Req'd Qty: 4.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: _____ Date: ____

QC:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date: Date: Run Start



Stop

Stop

Sequence ID/ **Work Center ID**

130

Packaging Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Oty

Reject Insp. Number

Stamp

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

N/O:			WC	ORK ORDER CHANG	GES				•
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No Do	QA:	Date:	
	Res	solution:						Date: _	
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DATE	STEP	Description of NC Corrective Action			ction B	Veri	fication	Approval	Approval
	0,2,	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ction C	Chief Eng	QC Inspector
		1							

Picklist Print

Friday, September 03, 2010 10:13:17 AM

Work Order ID: 61788

Parent Item:

D3781-041

Parent Item Name: Lateral Cushion Assembly



Start Date: 9/3/2010

Required Date: 9/13/2010

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 08-05-05 new issue DD verified by:EC

IPP Rev:B 08-07-22 revB as per dwg DD verified by:EC

IPP Rev:C 09-01-08 rev.C as per dwg DD verified by:ec

10.04.13 add remove fabric around holes DD verified

by:EC

as per dwg RevE DD 10.04.27 verified by:EC

IPP Rev:E

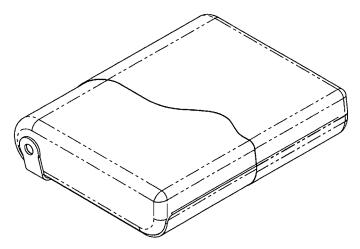
IPP Rev:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3781-1 Supporting Plate		Manufactured	No			100	Each	4.0000		4			100
				Location		Loc (Qt <u>v</u>	Loc Code					
				ST087	56026		4			<i>,</i> ,	- 24	019/14	ſ
d3781-041P		Purchased	No		56936	110	4 Each	0.0000	1	4//	1/2/2	2/	((4)

W/O:			WC	ORK ORDER CHANGE	ES				•				
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								Prod Mgr					
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Part No	:	PAR #:	Fault Cate				NCR: Yes No DQA: Date:						
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<u>D3781-041 LATERAL CUSHION ASSY</u> (UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



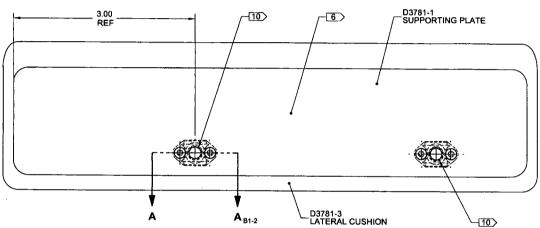
<u>D3781-043 ARMREST CUSHION</u> (UPHOLSTERY FABRIC NOT SHOWN PARTIALLY FOR CLARITY) SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK OR DER

RELEASED 2010 -04- 2.6

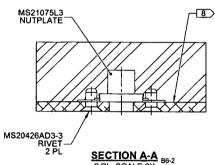
E	ACCOR	DINGLY	·. ·	URABILTY PER NCR 10-012.	МВ	10.04.14			
D	REDESI AT HAI	GNED I	BASED	ON FEEDBACK FROM END USERS	MB	09.05.21			
С	REDESI	GNED	FOR CO	MPATIBILITY WITH BHT 204 SEATS	MB	08.11.10			
В	REDESI	GNED;	ADDEC	DETAIL A (ZN B7-1)	MB	08.07.15			
Α	NEW IS	SUE	.1		MB	08.04.29			
REV.				DESCRIPTION	DESCRIPTION BY DA				
DESIGN			Js.	DART AEROSPA	ACE L	TD			
DRAWN	4		4	HAWKESBURY, ONTARIO, CANADA					
CHECK	ED	- 4	P	DRAWING NO.		REV. E			
MFG. A	PPR.	A		D3781		SHEET 1 OF 6			
APPRO	APPROVED W			TITLE		SCALE			
DE APP	DE APPR.			CUSHION ASSEMBL	Y	NTS			
DATE	10.0	4.14		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRATE AND CONFEDENTIAL AND IS REPRESE ON THE SUPPRESS CONCINON THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WINTON PERSONS ON FROM DART AEROSPACE LTD.					

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W/O:			W	ORK ORDER CHANG	GES		<u></u>			•
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STED	Description of NC			tion B		Verifi	cation	Approval	Approval
DAIL	STEP Description of NC Section A		Initial Action Descrip Chief Eng Chief Eng			Sign & Date	Section C		Chief Eng	QC Inspector

8 3 2 1 QTY -041 ITEM P/N DESCRIPTION D3781-041 **CUSHION ASSEMBLY** SUPPORTING PLATE LATERAL CUSHION 11 D3781-1 12 D3781-3 1 22 MS21075L3 NUT PLATE (OR MS21075-3) D SURREY SILVER SUNSET UPHOLSTERY FABRIC 23 A/R SY-111 A/R 1300 3M SCOTCH-GRIP ADHESIVE 25 4 MS20426AD3-3 RIVET 3.00 -6



D3781-041 LATERAL CUSHION ASSEMBLY (UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



2 PL, SCALE 2X

W/V 41788

DESIGN	1	DART AEROSPACE	LTD				
DRAWN	3	HAWKESBURY, ONTARIO, CANADA					
CHECKED	w	DRAWING NO.	REV. E				
MFG. APPR.	10.0	D3781	SHEET 2 OF 6				
APPROVED	W.	TITLE	SCALE				
DE APPR.	-#	CUSHION ASSEMBLY	NTS				
DATE 10.0	04.14	THIS DOCUMENT IS PRIVATE AND COMPRESSION, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COOPED OR DOMARKOATED TO ANY OTHER PRISSON WITHOUT					

D3781-041 NOTES:	
1) MATERIAL: COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLST	FRY FABRIC P/N SY-111
BOND FABRIC USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK)	NACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCH	HES PER INCH. LISE 1/2" MIN BACKSTITCH, NO LOOSE THERADS
POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.	TEG TER INGIN, OSE INE WINT BACKSTITCH, NO COOSE THREADS
2) FINISH: N/A	

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER

8

D

7) WEIGHT: 0.18 lbs

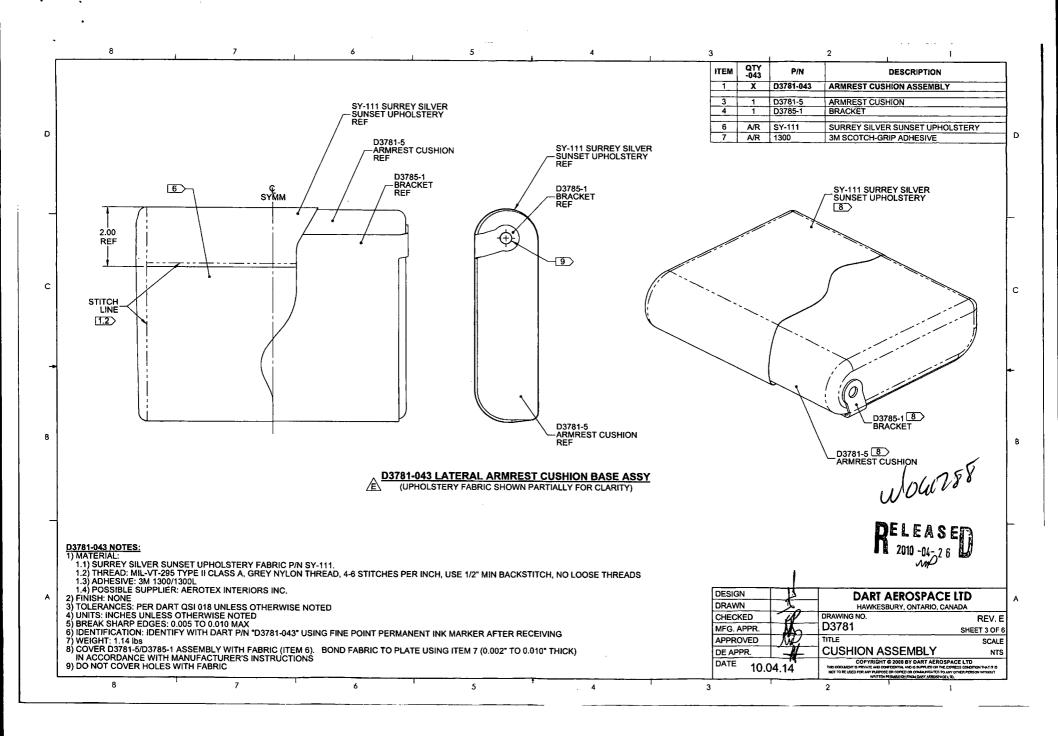
8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH D3781-1 SUPPORTING PLATE

6

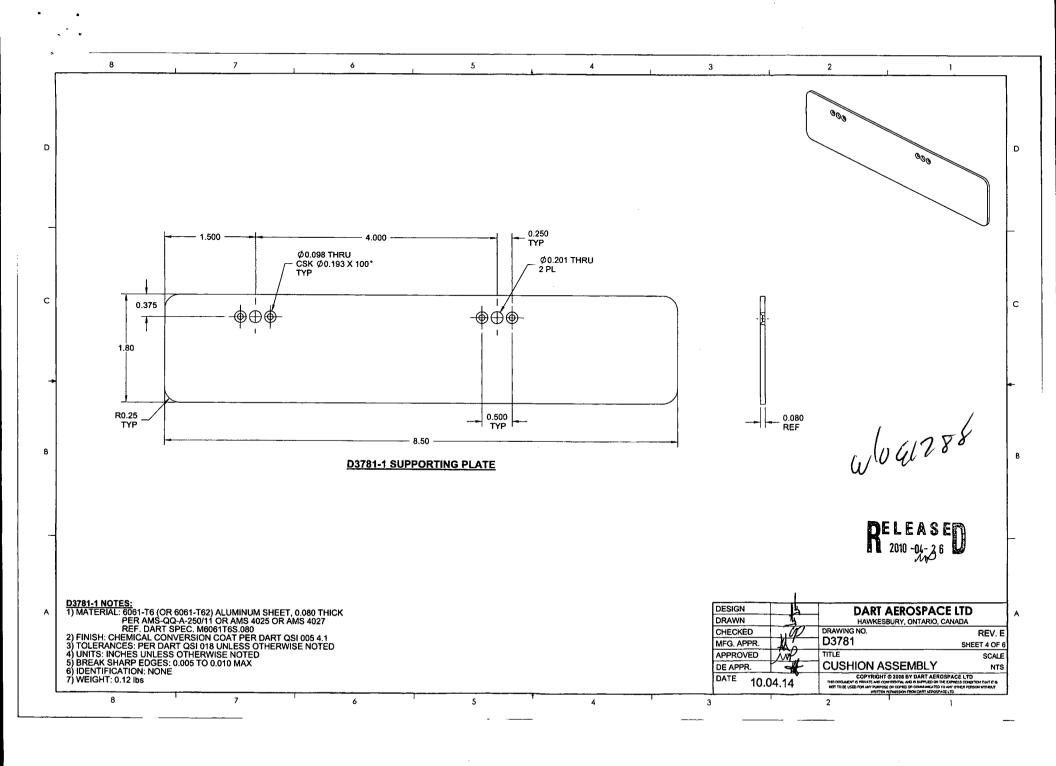
10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

3

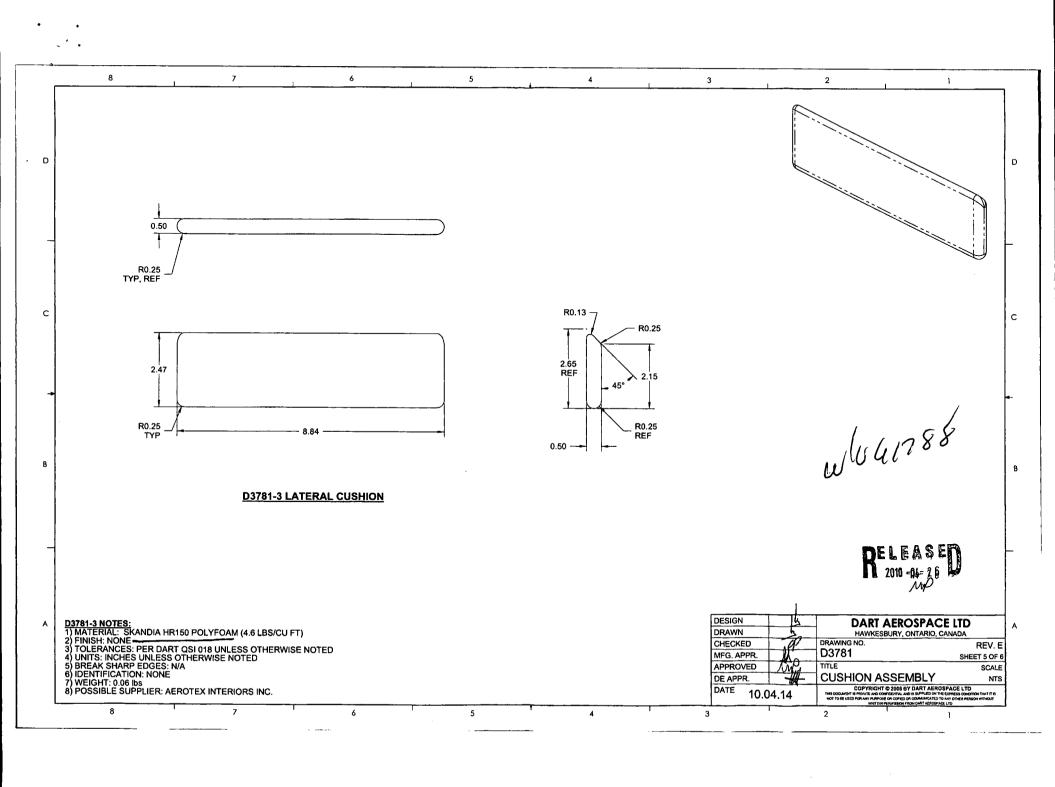
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W/O:			WORK ORDER CHANGES										
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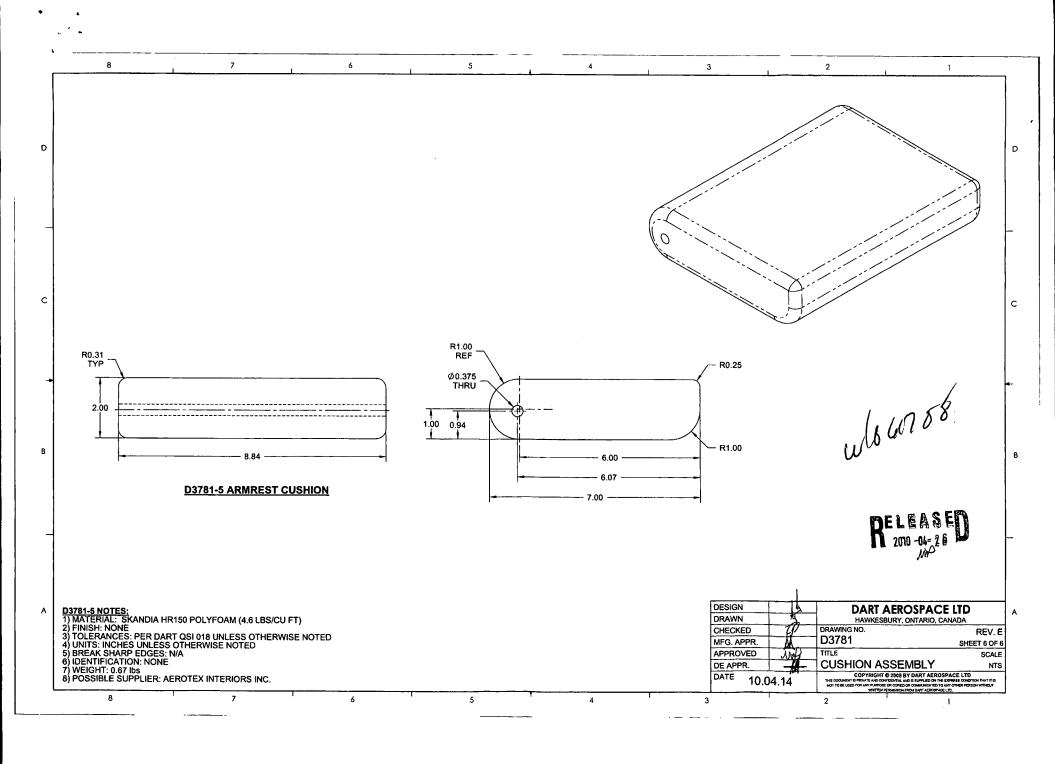
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	Re	solution:	Disposition	:	QA: N/C Cld	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP Description of NC	Corrective Action Section E			Verifica		Approval	Approval	
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DATE	STED	Description of NC		Corrective Action Section			Verific	cation	Approval	Approval		
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W/O:			W	ORK ORDER CHANG	ES			1 ,
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DATE	STEP	Description of NC	Description of NC Corrective Action Section			Verification	Approval	Approval
DATE		STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C	Chief Eng	QC Inspector
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W/O:			W	ORK ORDER CHANGE	S			- ' -
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DATE	STEP	Description of NC Corrective Action				Verification		Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector
								-
						,		



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO12504

Purchase Order Date 9/03/10 PO Print Date 9/03/10

Page Number 1 of 1

Order From:

VC-AER003

AEROTEX INTERIORS INC. #24-2333 18TH AVENUE N. E. CALGARY, AB T2E 8T6

CA

Contact Name

Vendor Phone

403 295 8770

Vendor Fax

403 313 0793

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms Currency

FOB

Chantal Lavoie

10127-2607 Net 30

د د شــــ

CAD

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA



Extended Unit Price Req Qty/ Ship Method Req Date/ Description/ Line Nbr Reference Price Mfg ID Taxable Unit of Measure Revision ID Vendor Part Number \$240.00 \$40.0000 FedEx PI ppd 9/13/10 _6.00 D3305-1P Cushion Each Yes AS PER DWG D3305 REV. B Special Inst: B61786 \$45.0000 \$270.00 FedEx PI ppd 6.00 9/13/10 D3306-041P Cover Assembly Each Yes AS PER DWG D3306 REV. B Special Inst: B61787 🗆 \$700.00 \$175.0000 9/13/10 3 d3781-041P Lateral cushion ass'y

Special Inst:

AS PER DWG D3781 REV. E

B61788

PO Total:

\$1,210.00

CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY

No substitution or deviation without

Certification required when applicable

Change Nbr:

Change Date: 9/03/10

consent. Certificate of Conformity or Material



Calgary, AB T2E 8T6 Phone: (403) 295-8770

Fax: (403) 313 0793

Ship To

Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7

[
Customer Phone	Customer Fax
613.632.5200	613.632.1053
Ship Via	Courier Acct No.
· FED EX	1517-9324-0

Packing Slip

Date	Packing Slip#
20/09/2010	7691

Invoice To

Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 Canada

Ship Date	P.O. No.
20/09/2010	PO12504

Aircraft Description Part Number Qty DART HEAD REST CUSHION AS PER DWG. D3305 HEAD REST COVER WITH 3 VELCRO CLOSURE AS PER DWG D3306-041P GST On Sales D3305-1P D3306-041P D3368-041P D3781-041P A A A A A A A A A A A A A
DART DART HEAD REST CUSHION AS PER DWG. D3305 HEAD REST COVER WITH 3 VELCRO CLOSURE AS PER DWG D3306-041P LATERAL CUSHION ASSY. GST On Sales D3305-1P D3306-041P D3781-041P

Thank you for doing business with Aerotex Interiors!

www.aerotexinteriors.com



CERTIFICATION OF CONFORMANCE

Customer Purchase Order: Our Work Order: PO12504 7691
THIS IS TO CERTIFY THAT THE FOLLOWING MATERIALS HAVE BEEN USED IN THE WORK ORDER STATED ABOVE:
FOAM - HR150 MATERIAL - SURREY SILVER SUNSET
THREAD - MIL-VT-295 TYPE II CLASS A, GREY HYLON THREAD
HAS BEEN FABRICATED TO ESTABLISHED SPECIFICATION TO CONFIRM WITH DWG NO. D3781-041p
SOLD TO: DART AEROSPACE LTD., 1270 ABERDEEN STREET, HAWKESBURY, ON K6A 1K7

AUTHORIZED REPRESENTATIVE

S